

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008839**Date Inspected:** 30-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	CWI: Liu Xiao Zhong /Chen Ying			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Tower components		

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Repair welding of weld Joint# 1A/B located on PCMK WSD1 FESA4-4 F/F. Welder is identified as 040775. ZPMC QC is identified as An Qing Xiang . The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2G (2F)-Repair.

Repair welding of weld Joint# 4A/B located on PCMK WSD1 FESA4-4 F/F. Welder is identified as 048810. ZPMC QC is identified as An Qing Xiang . The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2G (2F)-Repair.

Repair welding of weld Joint# 32A/B located on PCMK WSD1 FESA4-4 F/F. Welder is identified as 048810. ZPMC QC is identified as An Qing Xiang . The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2G (2F)-Repair.

SMAW Process:

Repair welding of weld Joint# 31A/B located on PCMK WSD1 FESA4-4 F/F. Welder is identified as 040655.

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ZPMC QC is identified as An Qing Xiang . The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-485-SMAW-2G (2F)-Repair.

Repair welding of weld Joint# 1A/B located on PCMK SD1 A 5002-1. Welder is identified as 046704. ZPMC QC is identified as Liu Jao Feng . The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-485-SMAW-2G (2F)-Repair.

Repair welding of weld Joint# 83A/B located on PCMK ESTL3-4 B/K. Welder is identified as 040611. ZPMC QC is identified as Liu Xiao Hong . The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-SMAW-2G (2F)-Repair.

Repair welding of weld Joint# 83A/B located on PCMK ESTL3-4 B/K. Welder is identified as 040733. ZPMC QC is identified as Liu Xiao Hong . The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-SMAW-2G (2F)-Repair.

Welding of weld Joint# 9B located on PCMK SD1 A 6002-7. Welder is identified as 041271. ZPMC QC is identified as Yu Dong Ping . The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-TC-U5b-1.

Welding of weld Joint# 7A located on PCMK SD1 A 6002-7. Welder is identified as 0047470. ZPMC QC is identified as Yu Dong Ping . The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-TC-U5b-1.

Bay# 10- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Root pass welding of weld Joint# 26 located on PCMK NSD1 FASA4-1 B/E-4. Welder is identified as 057244. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

Root pass welding of weld Joint# 26 located on PCMK NSD1 FASA4-1 B/E-4. Welder is identified as 052075. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract documents.

Summary of Conversations:

No relevant Conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

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Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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